# RAKU<sup>®</sup> TOOL IE-3235



## **35A Translucent**

## Flexible polyurethane

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## **Key Properties**

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI

### **Applications**

PC - Rev.-Status: 01- 2018/09/03

• For hand-batch processing or vacuum assisted processing

## **Processing Properties**

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	100
		pbv	100	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.21	ca. 1.21
Viscosity at 77°F (25°C)	ASTM D-2393	cР	ca. 200	ca. 2,050

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	сР	ca. 850
Gel time at 77°F (25°C)		min	10-15
Demold time at 77°F (25°C)		h	1-3

### **Cured / Mechanical Properties (approximate values)**

Cure 1: 24 hours at 77°F + 16 hours at 150°F Cure 2: 7 days at 77°F			Cure 1	Cure 2
Aspect	visual		Translucent	Translucent
Density	ASTM D-792	g/cm <sup>3</sup>	1.21	1.21
Shore hardness A	ASTM D-2240		30-40	30-40
Tensile strength	ASTM D-638	psi	250	200
Elongation at Break	ASTM D-638	%	360	150
Tear strength	ASTM D-624	pli	45	45
Linear shrinkage	ASTM D-2566	in/in	0.001-0.006	0.001-0.006

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#### **Processing**

#### The processing and material temperature should be between 68-77°F (20-25°C).

Due to variances in the raw materials that are used to manufacture this product, RAMPF Group Inc. will list the proper ratio of each manufactured batch and document this information **on the label**. Please follow the instructions given within the contents of **each specific batch** to ensure that you receive the desired cure and properties contained in this data bulletin. If you have questions about the listed ratio of your kit, contact your RAMPF Group Inc. representative.

Packaging	
IE-3235 Quart Kit	
IE-3235 1 Gal. Kit	Will your from botch to botch Diagon and notes above
IE-3235 5 Gal. Kit	Will vary from batch to batch. Please see notes above.
IE-3235 Drum Kit	

#### **Storage**

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (15°C to 30°C). If properly stored the products have the shelf-life indicated on the product label. Partly used containers should always be sealed appropriately and used up as soon as possible.

#### **Handling Precautions**

Good workplace ventilation is to be ensured during processing. At the same time, the employer's liability insurance association's industrial hygiene safety regulations regarding the handling of reaction resins and their hardeners are to be observed. Please take heed of the appropriate safety data sheets.

RAMPF Group, Inc. 49037 Wixom Tech Drive Wixom, MI 48393 T +1 248. 295.0223 F +1 248. 295.0224 E info.us@rampf-group.com Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights whatsoever affected thereby.